

SECONDARY SHAFT COMPONENTS INSPECTION

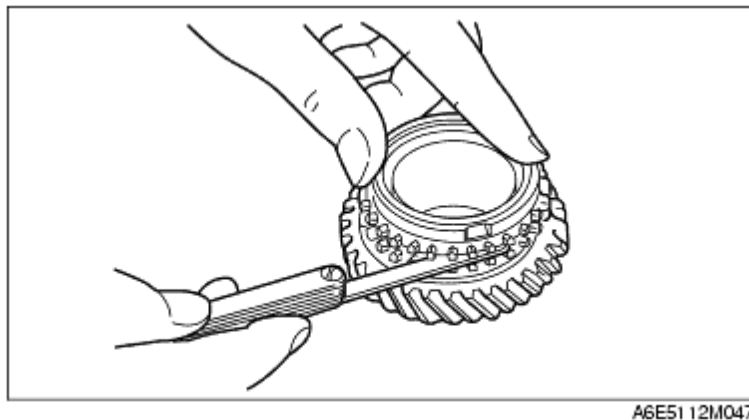
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Gears Inspection

1. Inspect the synchronizer cones for wear.
 - If there is malfunction, replace parts as necessary.
2. Inspect the gear teeth for damage, wear, and cracks.
 - If there is malfunction, replace parts as necessary.
3. Inspect the synchronizer ring matching teeth for damage and wear.
 - If there is malfunction, replace the synchronizer ring.

Synchronizer Ring Inspection

1. Inspect the synchronizer ring teeth for damage, wear, and cracks.
 - If there is malfunction, replace parts as necessary.
2. Inspect the tapered surface for wear and cracks.
 - If there is malfunction, replace parts as necessary.
3. Measure the clearance between the synchronizer ring and the side of gear circumferentially using a feeler gauge.

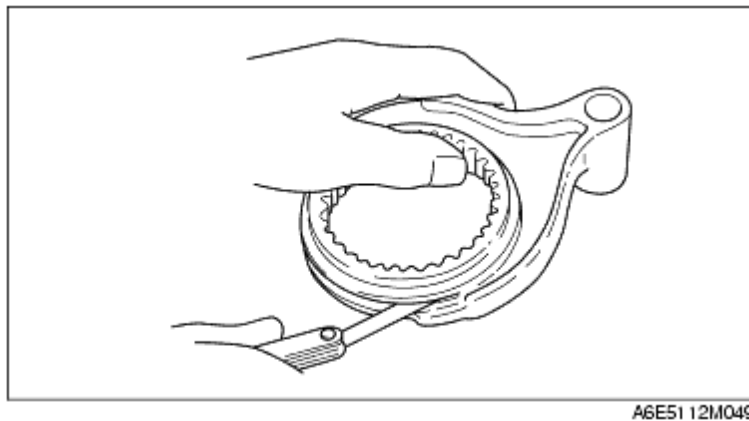


- If the clearance is exceed the minimum, replace the synchronizer ring.

Standard clearance
1.50 mm {0.059 in}
Minimum
0.80 mm {0.031 in}

Clutch Hub Component Inspection

1. Inspect the clutch hub sleeve and hub operation.
 - If there is malfunction, replace parts as necessary.
2. Inspect the gear teeth for damage, wear, and cracks.
 - If there is malfunction, replace parts as necessary.
3. Inspect the synchronizer keys for damage, wear, and cracks.
 - If there is malfunction, replace parts as necessary.
4. Measure the clearance between the hub sleeve and shift fork.



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- If the clearance exceeds the maximum, replace the hub sleeve and shift fork as a set.

Standard clearance
0.10-0.45 mm {0.004-0.017 in}
Maximum clearance
0.95 mm {0.037 in}

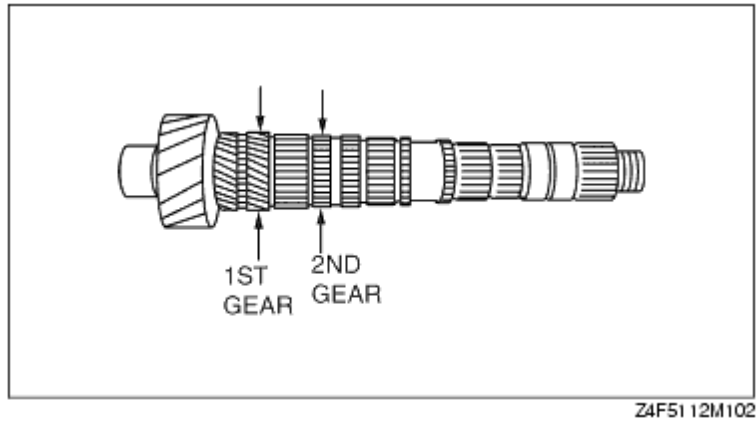
Secondary Shaft Gear Inspection

1. Inspect the gear contact surface for damage and wear.
 - If there is malfunction, replace the secondary shaft.
2. Inspect the splines for damage and wear.
 - If there is malfunction, replace the secondary shaft.
3. Inspect the gear teeth for damage, wear, and cracks.
 - If there is malfunction, replace the secondary shaft.
4. Inspect the oil passage for clogging.
 - If there is malfunction, replace the secondary shaft.
5. Measure the shaft gear runout.

- If not as specified, replace the secondary shaft.

Secondary shaft gear runout
0.015 mm {0.0006 in} max.

6. Measure the clearance between the shaft gears and the gears.



- If not as specified, replace parts as necessary.

mm{in}

| Gear | Shaft (outer dia.) | Gear (inner dia.) | Clearance |
|-------------|-------------------------------|------------------------------|---------------------------|
| 1st | 39.445-39.470 {1.553-1.554} | 39.500-39.525 {1.555-1.556} | 0.030-0.080 {0.002-0.003} |
| 2nd | 34.945-34.905 {1.376-1.374} | 35.015-35.035 {1.378-1.379} | 0.05-0.09 {0.002-0.003} |